

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001423**Date Inspected:** 02-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** 89 Meter Mockup**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Joe Lanz arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions during second shift. While on site the QA Inspector observed and/or discovered the following.

Bay 1

OBG Deck

The QA Inspector observed that power to bay 1 had been interrupted and no work was being performed. It appeared that several ZPMC personnel were waiting for the power to be activated to continue drilling operations and breaking of cut edges on previously cut plate for the closed rib OBG deck segments.

New Tower Shop

89 Meter Mockup diaphragms, MUSB-MA-21:

The QA inspector periodically observed in process grinding of MUSB-MA-21 diaphragm, piece mark SA13 to diaphragm plate piece mark p55 complete joint penetration weld number 63. Two ZPMC personnel performed the grinding. The weld surface was ground to a smooth finish. The work observed by the QA Inspector appears to meet the minimum requirements in accordance with the contract documents.

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Cutting Facility

The QA inspector observed there was no work performed in the cutting facility on this date. The previously cut plate was stored on wood dunnage and appeared to be properly marked in accordance with contract requirements. The QA inspector observed that completed floor plates for the orthotropic box girders were stored immediately outside the cutting facility. The floor beams were stored off the ground on wood and were covered with tarps.

Summary of Conversations:

No relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
